

9

Date: Monday, 1/7/2008 4:26:19 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 36652B		
Estimate Number	: 12356		
P.O. Number	:	Part Number	: D41269402
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: D412-694
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : SMALL /MED FAB	Drawing Revision	: C1
Previous Run	: 27445	Material	:
Written By	:	Due Date	: 2/28/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>18.08.01.8</u>		
Comment	: Est Rev: A 05.12.09 New Issue KJ/RF		
	: Est Rev B 06.04.18 New dwg rev. ecn781 EC		
	: Est Rev: C 06.07.10 Revised per B24659 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Issue red decal labels for D412-694-02. CHG005

2.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-02 Drill Process

1- D412-694-02 Drill Process Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-02 as per Dwg D412-694 page 4 (view P).

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P). Note: D3151-041 orientation in the door.

3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).

4- Drill Ø(#30) holes using drill Jig D3144-T7 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T8/-T9 as per Dwg D412-694 page 2.
 Note: The (12) holes for the (6) nut plates cannot be less than 0.290" from inside edge.

5- Use unibit to open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-042 cover assembly as per Dwg D412-694 page 4 (view P).

Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.

6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-7. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).

7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578)

mlo8/02/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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for inserts as per Dwg D412-694 page 2, page 6 (view H, J).

8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-9 RH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts.

9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-042 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q).

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover take the measurement 0.250" from each corner of the D3163-042 cover.

ml 08/02/04

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total : 55.0000 Each(s)

Insert

Batch

A/R Hysol EA934NA

Expiry Date:

m 19443

m 107007

31 jan. 2009

ml 08/02/04

B/w
don't
match *

5.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q).

2- Sand flush excess Hysol around the insert on both doors.

ml 08/02/07

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface.

7.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045

Primer Filler

Batch:

106 803

A/R 12375S

Reducer

Batch:

106 803

7T 08-02-08

Dart Aerospace Ltd

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8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

D31105

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

Batch

B27081

ml

10.0

D31151

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B36152

ml

11.0

D31167

Seal ZX2054



Comment: Qty.: 5.6666 f(s)/Unit Total : 5.6666 f(s)

Seal ZX2054

Batch

B27239

ml

12.0

D31169

Seal ZX1267



Comment: Qty.: 6.4166 f(s)/Unit Total : 6.4166 f(s)

Seal ZX1267

Batch

B17463

ml

13.0

D3121041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Bracket Assembly

Batch

B 21167 X 1
B 24338 X 1
B 24677 X 1

ml 08/02/19

14.0

D3121044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

Batch

B 21167

ml 08/02/08

Dart Aerospace Ltd

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Description :

15.0

D31221

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lever

Batch

B25539

ml

16.0

D31231

Cam



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cam

Batch

M10536-17

ml

17.0

D31241

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

ml

18.0

D31242

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Hook

Batch

M10536-17

ml

19.0

D31261

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

~~B18657~~

B36728

ml

ml 08/02/19

20.0

D31263

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket

Batch

B24680

ml

21.0

D31265

Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

Batch

B18658

x5 ml 08/02/15

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Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D3132042

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17

ml

23.0

D3133041

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17

ml

24.0

D3135041

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch

B36730 ✓

ml

25.0

D3137045

BRACKET ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET ASSEMBLY

Batch

B27339

ml

26.0

D31382

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

B23121 B

ml 08/02/19

27.0

D31391

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B18863

ml

28.0

D31394

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B24751

ml

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D314006

Door Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Kit

Batch

B 36652B M106688 mini 2008/2/5

ml

30.0

D31411

Spring #204-032-734-001



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring #204-032-734-001

Batch

B34725

ml

31.0

D314413

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B21911

ml

32.0

D3144111

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B21910

ml

33.0

D3144115

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B22021

ml

34.0

D3144123

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B22025

ml

35.0

D31481

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Batch

M 10536-17

ml 08/02/08

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Part Number: D41269402

Job Number:



Seq. #:	Machine Or Operation:	Description :
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36.0	D3151041	Doubler Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Doubler Assembly
Batch B24685

ml

37.0	D3152042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B25285

ml

38.0	D3155041	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B27178

ml

39.0	D3155042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B26933

ml

40.0	D31561	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bracket
Batch B24772

ml

41.0	D3162041	Bracket Assembly
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bracket Assembly
Batch B36733 (x7)

(x3) B37155 *ml* 08/02/19

42.0	D3162043	BRACKET ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B36949

ml 08/02/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 36652B

Part Number: D41269402

Job Number:



Seq. #:	Machine Or Operation:	Description :
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43.0	D3162044	BRACKET ASSEMBLY
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B36734

ml

44.0	D3163042	Cover Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Cover Assembly
Batch 307484

ml

45.0	D3183042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B37195

ml

46.0	D32031	Handle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Handle
Batch B30158A

ml

47.0	D33081	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Doubler
Batch B21912

ml

48.0	AN52510R6	Screw
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Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Screw
Batch M15943

ml

49.0	AN52510R7	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw
Batch M106166

ml

ml 08/02/07

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

50.0

AN960JD8

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M106112

ml

51.0

AN960JD10L

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch

104374

ml

52.0

AN960JD10LL

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total : 15.0000 Each(s)

Washer

Batch

M19600

ml

53.0

AN960JD416L

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch

M106303

ml

54.0

BSP45

Commercial Rivet



Comment: Qty.: 79.0000 Each(s)/Unit Total : 79.0000 Each(s)

Commercial Rivet

Batch

11821

ml

55.0

BSP46

Commercial rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Commercial rivet

Batch

M101237

ml

56.0

M7885243

~~CR 8213-403~~

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch

14477

ml 08/01/17

W/O:		WORK ORDER CHANGES					
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Description :

57.0

M7885344

Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivets

Batch

M7885
** M15655(x6)*

M19099(x6)

ml

58.0

MS203922C9

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M11784

ml

59.0

MS203922C17

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M18949

ml

60.0

MS203923C21

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M104156

ml

61.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch

M1563

ml

62.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch

M3459

ml

63.0

MS20426AD46

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch

M103395

ml 08/01/17

W/O:		WORK ORDER CHANGES					
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64.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
Batch m105054

ml

65.0

MS21042L08

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Nut
Batch m105925

ml

66.0

MS21072L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nutplate
Batch m107003

ml

67.0

MS24665151

Cotter Pin



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Cotter Pin
Batch m14526

ml

68.0

MS24693S271

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
Batch m14478

ml

69.0

MS24694C5

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
Batch m11755

ml

70.0

MS24694S5

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Screw
Batch ~~MS24694~~ m18949

ml

ml 08/02/07

Dart Aerospace Ltd

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Description :

71.0

MS24694S50

Screw



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Screw

Batch

M104625

ml

72.0

MS24694S98

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Screw

Batch

103684

ml

73.0

MS27039105

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

M3501

ml

74.0

MS27039106

Screw



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Screw

Batch

M11754

ml

75.0

MS27039108

Screw



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Screw

Batch

M105076

ml

76.0

MS35275233

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Screw

Batch

11822

ml

77.0

MS35649264

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

11822

ml 08/01/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 4:26:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

78.0

MS356503252

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

11735

ml

79.0

MS518597

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Washer

Batch

M106421

ml

80.0

NAS43DD310

Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

M19099

ml

81.0

NAS43DD314

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

M19347

ml 08/01/17

82.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-02 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-043/-044.

2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

3- Connect D3132-042 Rod Weldment with D3122-1 Lever and D3133-042 Rod Weldment as per Dwg D412-694 page 4 (view P).

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and page 2. Adjust rod weldment until everything works properly and looks in place.

ml 08/02/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 4:26:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

83.0

QC5

INSPECT WORK TO CURRENT STEP



08-02-21



Comment: INSPECT WORK TO CURRENT STEP

84.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-02 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

2- Install D3110-5 Handle Assembly in the D3163-042 Cover Assembly. Ensure Handle works freely. Ensure D3163-042 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

4- Open 15/64" (0.234) holes to D3163-042 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-4 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

A/R RTV732 Clear Batch: M105700 Expiry: 23 July 2009

7- Install D3126 Brackets and D3138-2 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

m/08/02/21

85.0

QC5

INSPECT WORK TO CURRENT STEP



Done



Comment: INSPECT WORK TO CURRENT STEP

86.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Finish installing D3163-042 in the door.

2- Install red decal before closing cover. *m/08/02/21*

m/08/02/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/02/26</u>	<u>1</u>	<u>Scrap one DB150-2 when install door on track up</u>		<u>Took out part destroy it and replace by new one DB150-2 11/50</u>				

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 4:26:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 36652B

Part Number: D41269402

Job Number:



Seq. #:

Machine Or Operation:

Description :

87.0

QC5

INSPECT WORK TO CURRENT STEP



Test D. + test

Joel



Comment: INSPECT WORK TO CURRENT STEP

Install door on mock up helicopter to insure proper fit and function.

88.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

C 2008/02/26 ①

89.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/26 ①

Job Completion



2008/2/26

①

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
	X			D412-694-02	DOOR ASSEMBLY
		X		D412-694-03	DOOR ASSEMBLY
			X	D412-694-04	DOOR ASSEMBLY
		1	1	D3110-1	ESCUTO-EON
		1	1	D3110-3	HANDLE
		1	1	D3110-5	HANDLE ASSEMBLY
1	1			D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0680	SEAL
1	1			D3116-7-0680	SEAL
1	1			D3116-9-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
		1		D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
		1		D3120-2	COVER
		1		D3120-3	COVER
		1		D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1				D3121-043	BRACKET ASSEMBLY (ROLLER)
	1			D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOCK
1	1			D3124-2	HOCK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1				D3132-041	RCD WELDMENT
	1			D3132-042	RCD WELDMENT
	1			D3133-041	RCD WELDMENT
1				D3133-042	RCD WELDMENT
		1	1	D3134-1	RCD
		1	1	D3134-3	RCD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1				D3138-1	COVER
1	1			D3138-2	COVER
1	1			D3139-1	GUIDE
1	1			D3139-3	GUIDE
1	1			D3139-4	GUIDE
1				D3140-05	DOOR
1				D3140-06	DOOR
		1		D3140-07	DOOR
2	2			D3140-08	DOOR
		1	1	D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
1				D3144-3	DOUBLER
		1		D3144-105	DOUBLER
		1		D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
	1			D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1	1	D3145-2	HINGE BRACKET
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		2	2	D3147-1	FIN
2	2			D3148-1	CLEVIS
		2	2	D3149-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
	1			D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
		1		D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1		1		D3162-043	BRACKET ASSEMBLY
1		1		D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
1				D3163-042	COVER ASSEMBLY
1				D3163-041	BRACKET ASSEMBLY (ROLLER)
1				D3163-042	BRACKET ASSEMBLY (ROLLER)
1				D3203-1	HANDLE ASSEMBLY
2	2			D3206-1	DOUBLER
55	55	21	21	80-005-248	INSERT (OR SL2052-3-4)
10	10			AN625-10F6	SCREW
8	8	4	4	AN625-10F7	SCREW
		8	8	AN680D10	WASHER
18	18	4	4	AN680D10L	WASHER
13	13	32	32	AN680D10LL	WASHER
6	6			AN680D1416L	WASHER
		4	4	AN680D16L	WASHER
6	6			AN680D18	WASHER
		2	2	AN680D18L	WASHER
		2	2	AN680D18LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FV10-032	WASHER
		6	6	FV14-032	WASHER
12	12			M7885/24	RIVET (OR CR32134-3)
		3	3	M7885/34	RIVET (OR CR32124-3)
		2	2	MS20392-1C11	FIN
		7	7	MS20392-2C15	FIN
2	2			MS20392-2C17	FIN
2	2	2	2	MS20392-2C9	FIN
2	2			MS20392-3C21	FIN
8	8			MS20426A05	RIVET
12	12			M7885/3-4	Rivet
8	8			MS20426AB4	Rivet

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AB4	RIVET
		6	6	MS21042L05	NUT
6	6	2	2	MS21042L06	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUT/PLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24665-S271	SCREW
		2	2	MS24694-04	SCREW
4	4			MS24694-05	SCREW
6	6			MS24694-S5	SCREW
18	18			MS24694-S50	SCREW
		4	4	MS24694-S56	SCREW
		2	2	MS24694-S53	SCREW
4	4	4	4	MS24694-S80	SCREW
				MS24694-S88	SCREW
		2	2	MS25261-R6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35205-231	SCREW
2	2			MS35275-233	SCREW
2	2			MS35649-254	NUT
		4	4	MS35650-3051	NUT
2	2			MS35650-3252	NUT
2	2	3	3	MS31859-7	WASHER
		4	4	NAS1165-10L	WASHER
		14	14	NAS3088-6-SP	SCREW
		15	15	NAS3818P	WASHER
7	7			NAS40000-10	SPACER
6	6			NAS40000-14	SPACER
		2	2	NAS40000-40	SPACER

GENERAL NOTES:

1. FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREWS INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOFF SHOWN IN VIEW N.
2. IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF: 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
3. HOLES AND PARTS TO BE LOCATED PER DRILLING JGS. B30-23000-01; D3144-TV-12-T3; D31803-3; D3162-041T1 (FOR -01 DOOR ASSY); B30-23000-02; D3144-T7-T8-T9; D31803-8; D3162-041T2 (FOR -02 DOOR ASSY); D3144-T4-T5-T6; D3119-041T1; D3112-TV-T2 (FOR -03 DOOR ASSY); D3144-T10-T11-T12; D3119-042T1; D3112-TV-T2 (FOR -04 DOOR ASSY).
4. INSTALL INSERTS PER PART Q3 005. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
5. TOLERANCES ARE PER PART Q3 018 UNLESS OTHERWISE NOTED.
6. ALL DIMENSIONS ARE IN INCHES.
7. IDENTIFY D412-694-01/-02/-03/-04 DOOR ASSEMBLIES USING D2729-1 DECALS.

CI	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	DRAWING NO. D412-694
		TITLE DOOR ASSEMBLY
		REV. C SHEET 1 OF 6 SCALE NTS

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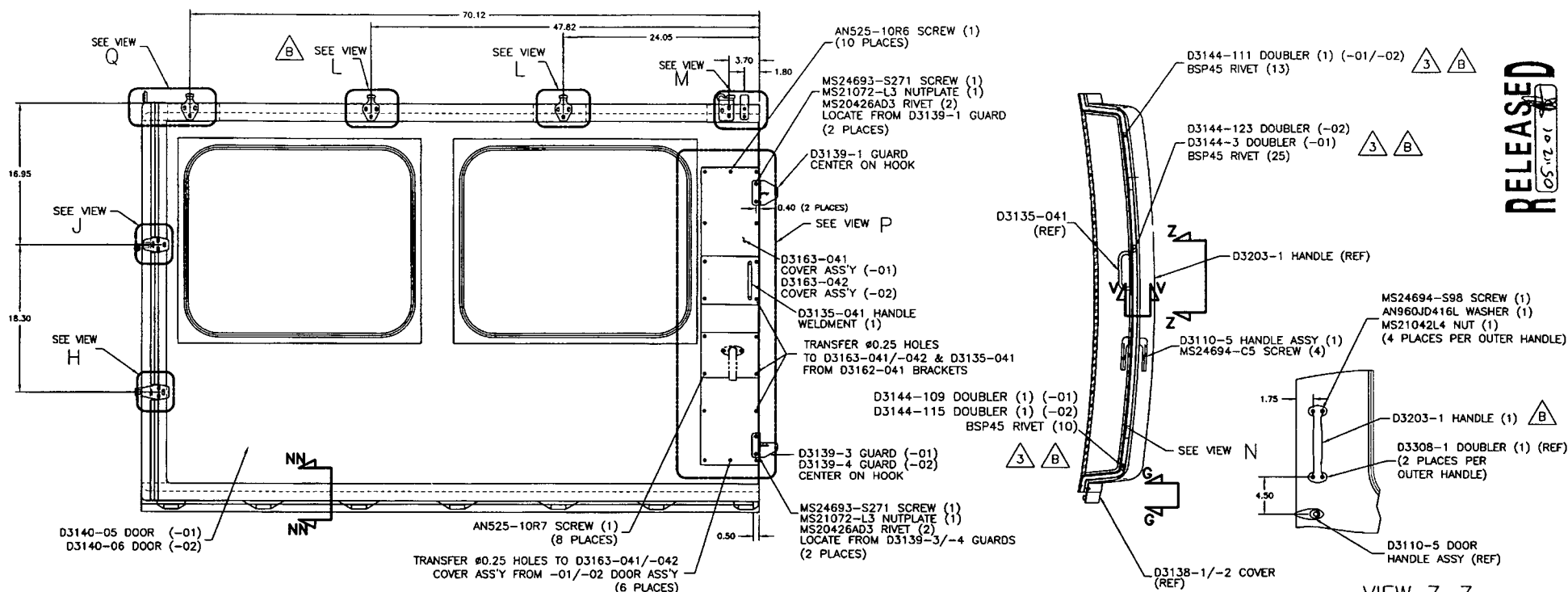
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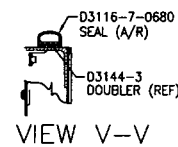
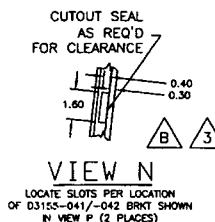
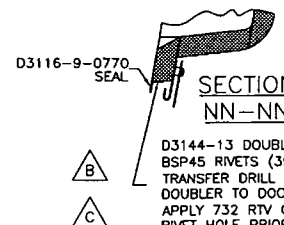
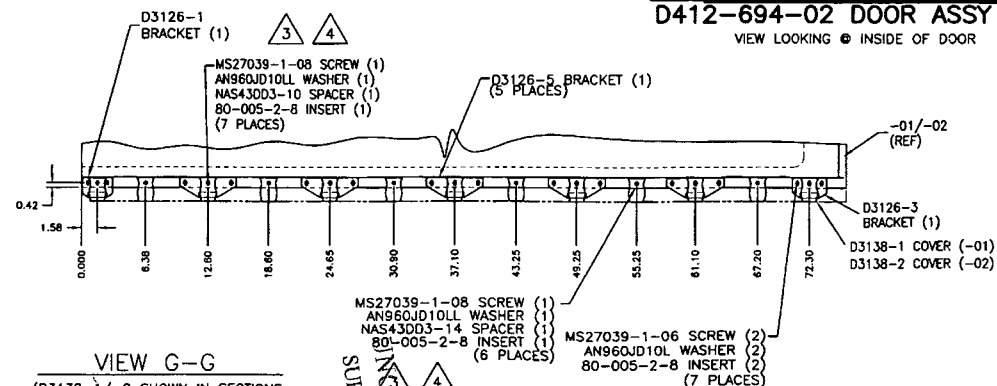
RELEASED
05.12.01

RELEASED
05.12.01



**D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)**

VIEW LOOKING @ INSIDE OF DOOR



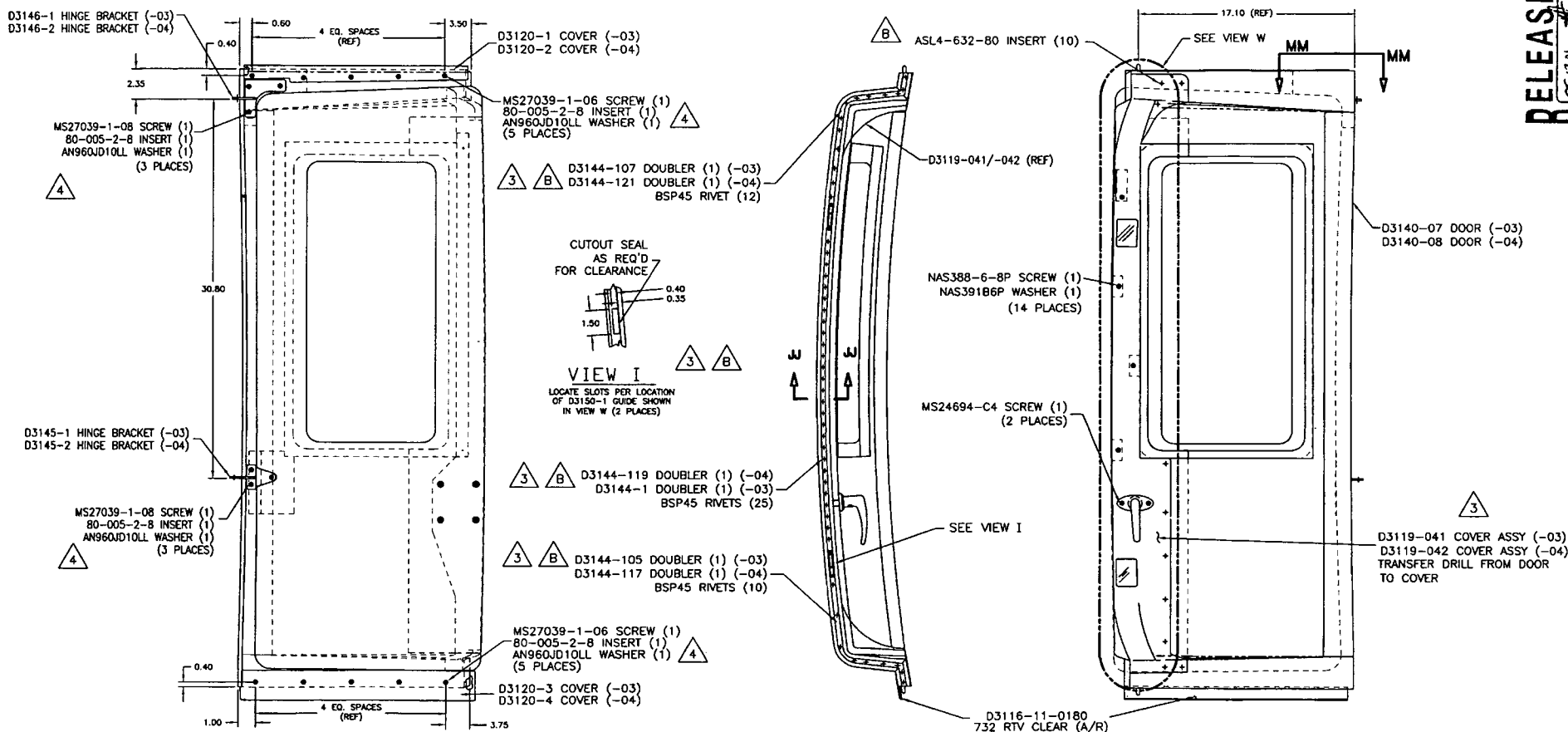
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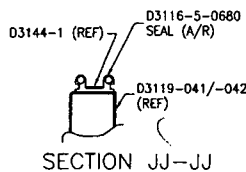
DESIGN CP	DRAWN BY RF	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D412-694	REV. C SHEET 2 OF 6
DATE 05.11.23	TITLE DOOR ASSEMBLY	SCALE NTS	

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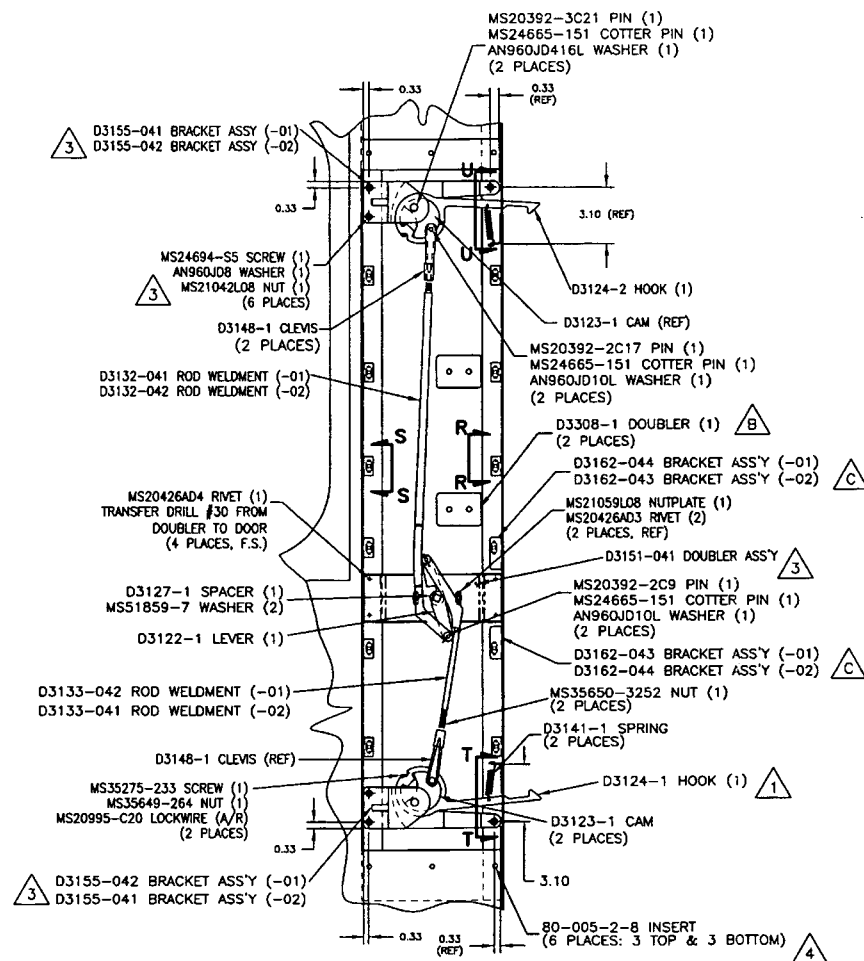
D412-694-03 DOOR ASSY (SHOWN)
D412-694-04 DOOR ASSY (OPP)



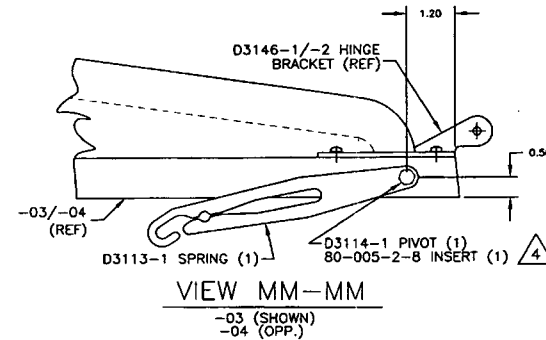
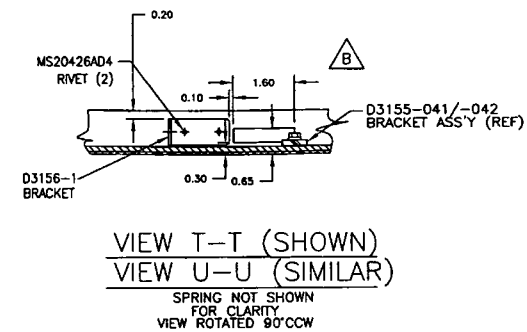
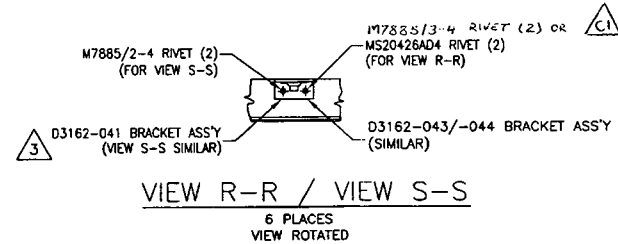
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DATE 05.11.23		TITLE DOOR ASSEMBLY		SCALE NTS	

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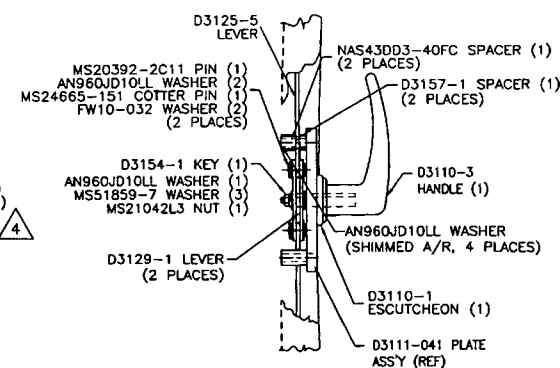
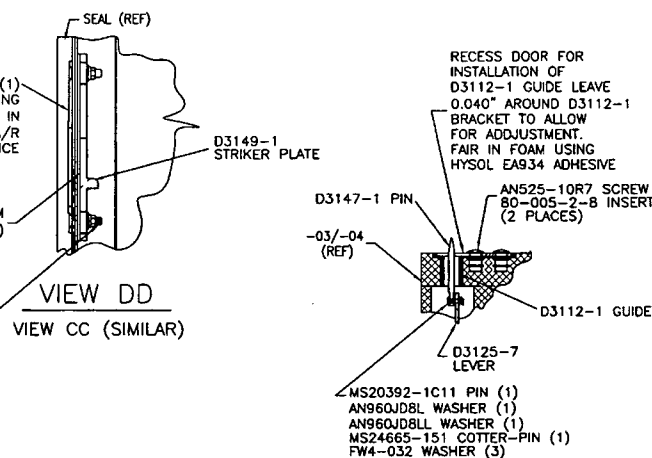
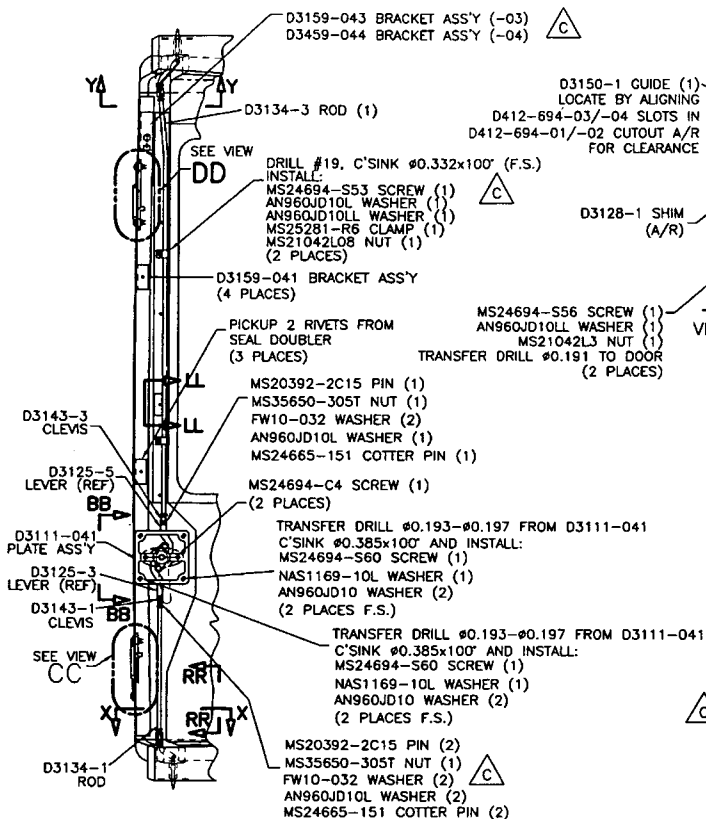


VIEW P
D3163-041/-042 COVER NOT
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NO. 366527B

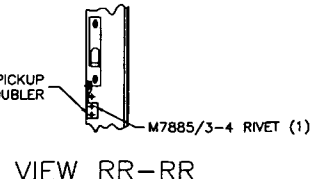
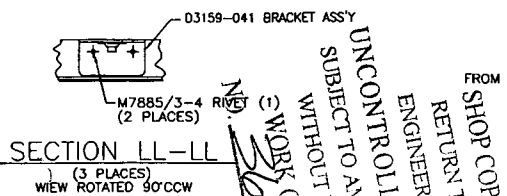
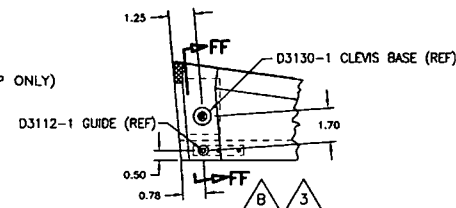
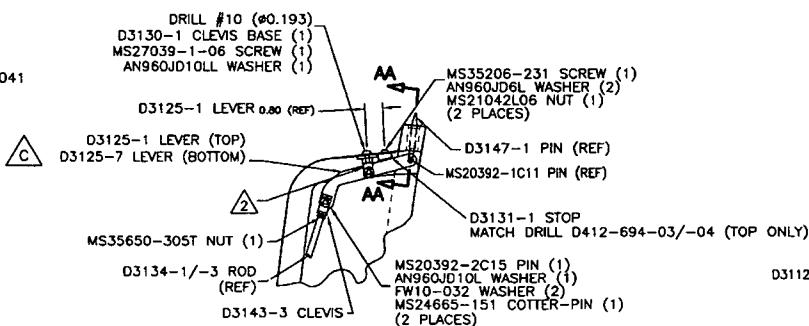
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VIEW W

D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY

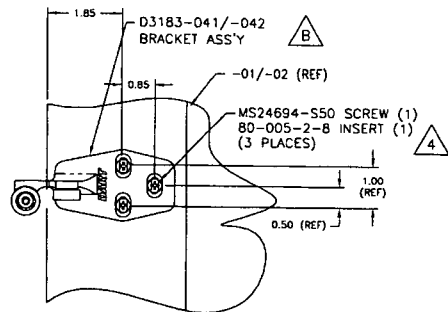
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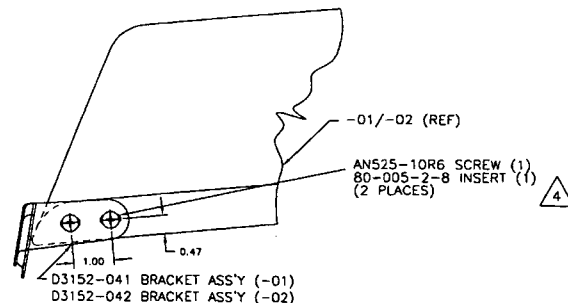
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		DATE	05.11.23	TITLE		SCALE	NTS
				DOOR ASSEMBLY		SHEET 5 OF 6	

RELEASED

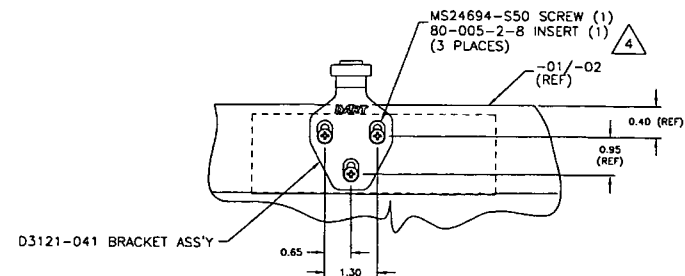
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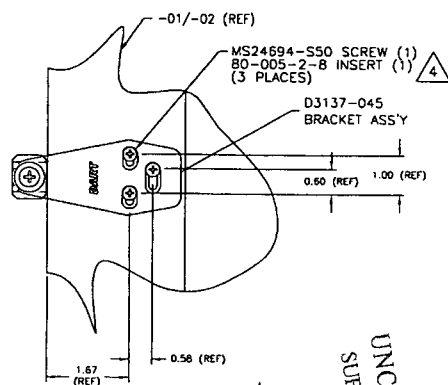
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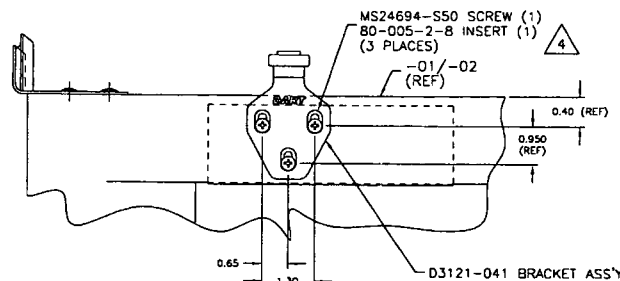
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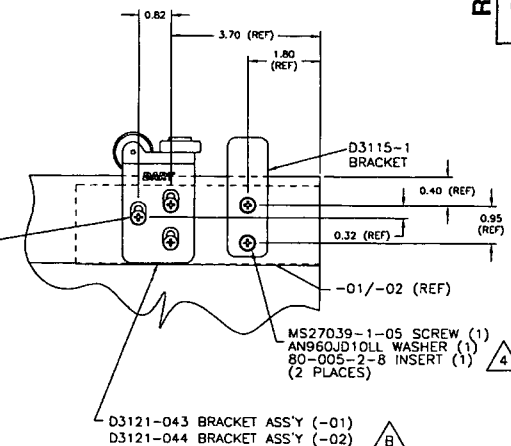
VIEW L



VIEW H



MS24694-S50 SCREW (1)
80-005-2-8 INSERT (1)
(3 PLACES)



VIEW M

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DATE 05.11.23		TITLE DOOR ASSEMBLY	SCALE NTS